

Work Order ID 62705

Wednesday, October 06, 2010 3:20:54 PM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 10/6/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

364. 063

B 10-10-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-7

(20)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/10/08

count for
(x20)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(20)			
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 <input type="checkbox"/> Form Joggle as per Dwg D3537 on brake using Jig DT8158	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00				(20)			
Quality Control	Memo Ensure joggle as per dwg D3429	0.00							
150 Large Fab	Large Fab	0.00							
Large Fab	Memo Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat M116450 <input type="checkbox"/> Weld hardcoat as per Dwg D3437	0.00							

SB 10/10/12

S 10/10/13

count

EL 10-10-25 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/125

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/125

counted
x20

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M112588

START TIME:

2:00

OVEN TEMPERATURE:

320° FINISH TIME:

2:30

20 10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 10/6/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M

10/10/27

20

/

200

Identify as per dwg & Stock Location

FD-17

0.00



Packaging

Memo

0.00

Packaging

20.

BR 10/10-27.

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28

ME

10-10-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:20:58 PM

Page 1

Work Order ID: 62705



Parent Item: D3537-3



Parent Item Name: Wearpad



Start Date: 10/6/2010

Required Date: 10/6/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	70.6100	0.149	2.509474			
304/316 Sheet .063												10-10-7	

Location

Loc Qty

Loc Code

MAT

64.77

111323

0

115688

64.77

MAT20

5.84

115440

5.84

115688

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62705
Description: Wearpad		Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.863	*		V HB02	
3.500	+/-0.010	3.501	*		V	
1.965	+/-0.010	1.967	*		V	
2.795	+/-0.010	2.795	x		V	
3.625	+/-0.010	3.626	*		V	
0.220 x 0.380	+/-0.010	0.221 x 0.380	*		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-10-7	Date: 10/10/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJJ/JLM	B

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SHOP COPY

REVIEW

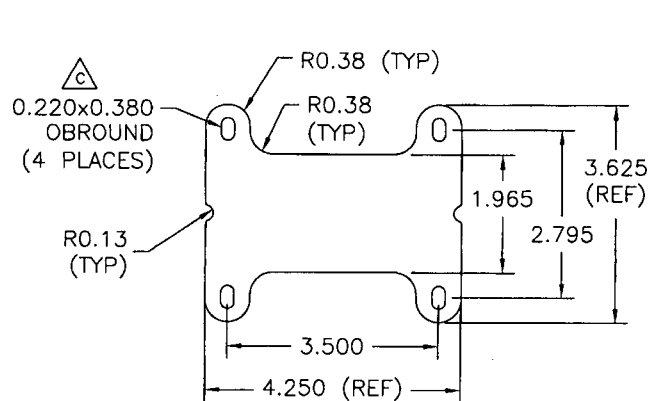
ENCLOSURE

UNCONTROLLED COPY
SUBJECT TO

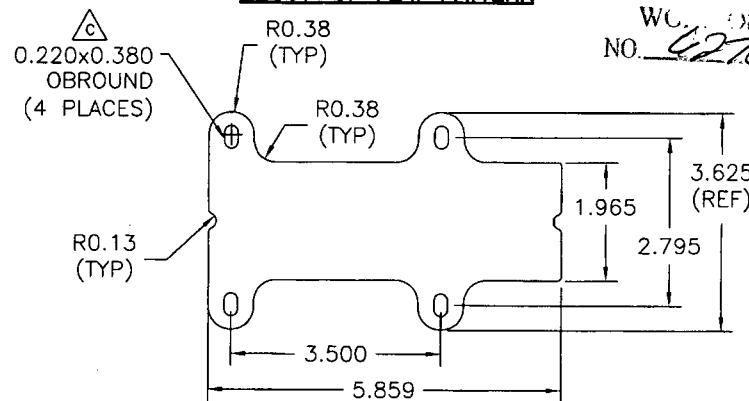
WORK ORDER NO.

42705
PHO-1006

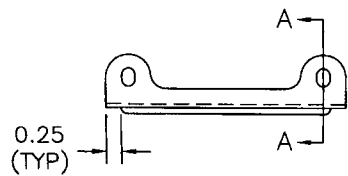
D3537-1F FLAT PATTERN



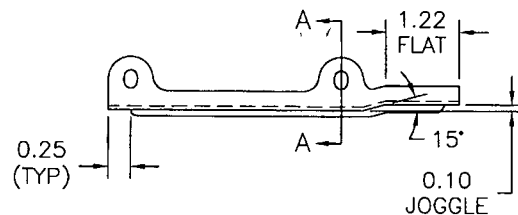
D3537-3F FLAT PATTERN



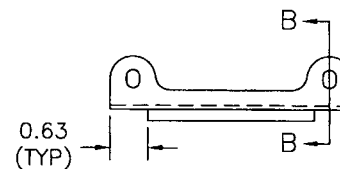
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



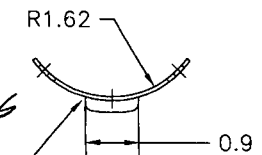
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

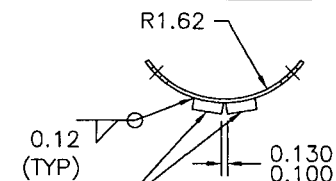


SECTION A-A



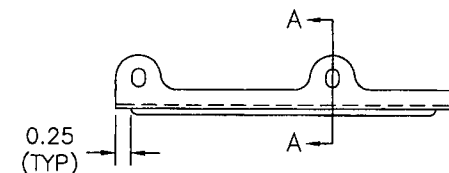
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	
DRAWING NO.	D3537	REV. C
TITLE	WEARPAD	SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08
PER ELN
962

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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